

# Work Order ID 64731

December 14, 2010 12:51:07 PM



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Item ID: D3278-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Assembly

Start Date: 12/14/10 Start Qty: 20.00



Cust Item ID:

Required Date: 12/15/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Rivet spacers with support as per Dwg D3278.

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble support as per Dwg D3278. \*\*\*DO NOT TIGHTEN  
BOLTS\*\*\* Identify as D3278-041

*ES 10/12/14* (20)

*QC5*  
(470)

*ES 10/12/15* (20)

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Item ID: D3278-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Assembly

Start Date: 12/14/10 Start Qty: 20.00



Cust Item ID:

Required Date: 12/15/10 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 4605t

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

accept  
(420)

Capin (20)

[Signature] 10/12/2010

CL 10/12/17

# Picklist Print

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Work Order ID: 64731

Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 12/14/10

Required Date: 12/15/10

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐

IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-13A

Purchased

No

120

Each

452.0000

2

40



Bolt

Location

Loc Qty

Loc Code

ST357

452

116191

452

120

Each

30.0000

4

80

AN960JD416

NAS1149D0463J

Purchased

No



Washer

DM116289 (800)

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

D2230-1

Manufactured

No

120

Each

142.0000

2

40



Lug

Location

Loc Qty

Loc Code

ST430

80

63998

80

ST476

62

62665

2

63319

60

40

4510/12/15

40  
4510/12/15

40  
4510/12/15

# Picklist Print

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Work Order ID: 64731

Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 12/14/10

Required Date: 12/15/10

Start Qty: 20.00

Required Qty: 20.00

D3278-1  
Support  
Manufactured No

100 Each 31.0000 1 20

Location Loc Qty Loc Code

ST045 24

60564 4

62021 20

ST048 7

51353 7

D3278-2  
Support  
Manufactured No

100 Each 30.0000 1 20

Location Loc Qty Loc Code

ST045 21

62022 21

ST048 9

60565 9

D3278-3  
Spacer  
Manufactured No

100 Each 74.0000 1 20

Location Loc Qty Loc Code

ST045 74

60244 74

MS20426AD3-6  
Rivet  
Purchased No

120 Each 4,884.000 4 80

Location Loc Qty Loc Code

ST316 4884

105055 1314

116289 3570

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Shop Packet Print

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# Picklist Print

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Work Order ID: 64731

Parent Item: D3278-041

Parent Item Name: Support Assembly



Start Date: 12/14/10

Required Date: 12/15/10

Start Qty: 20.00

Required Qty: 20.00

MS21042L4

Purchased

No

100

Each

4,642.000

2

40



Nut



*EP 10/12/15*

Location

Loc Qty

Loc Code

ST300

4642

1123143

2

115589

40

115621

1100

116188

3500

*40*

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Shop Packet Print

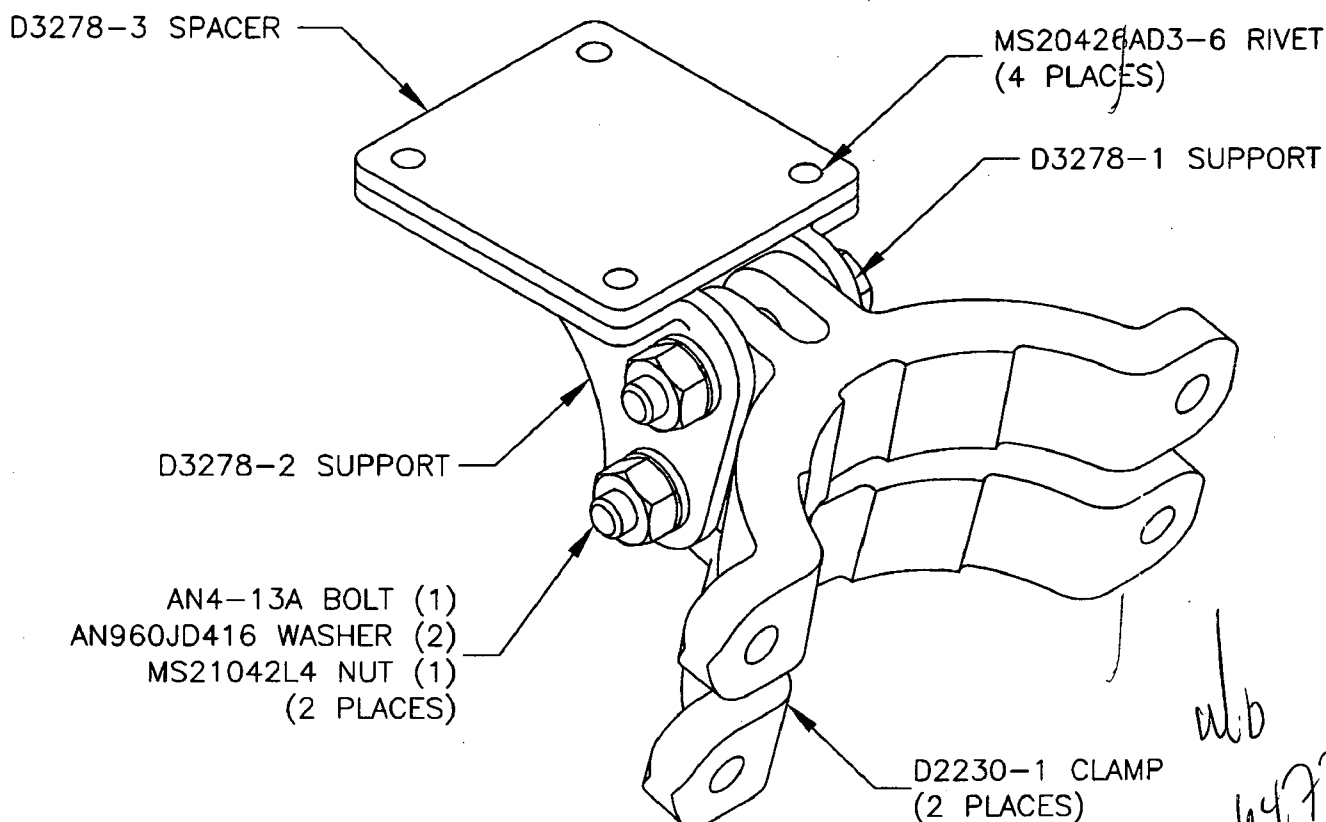
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**DART**

DESIGN 97	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
07-08-08

## D3278-041 SUPPORT ASSEMBLY



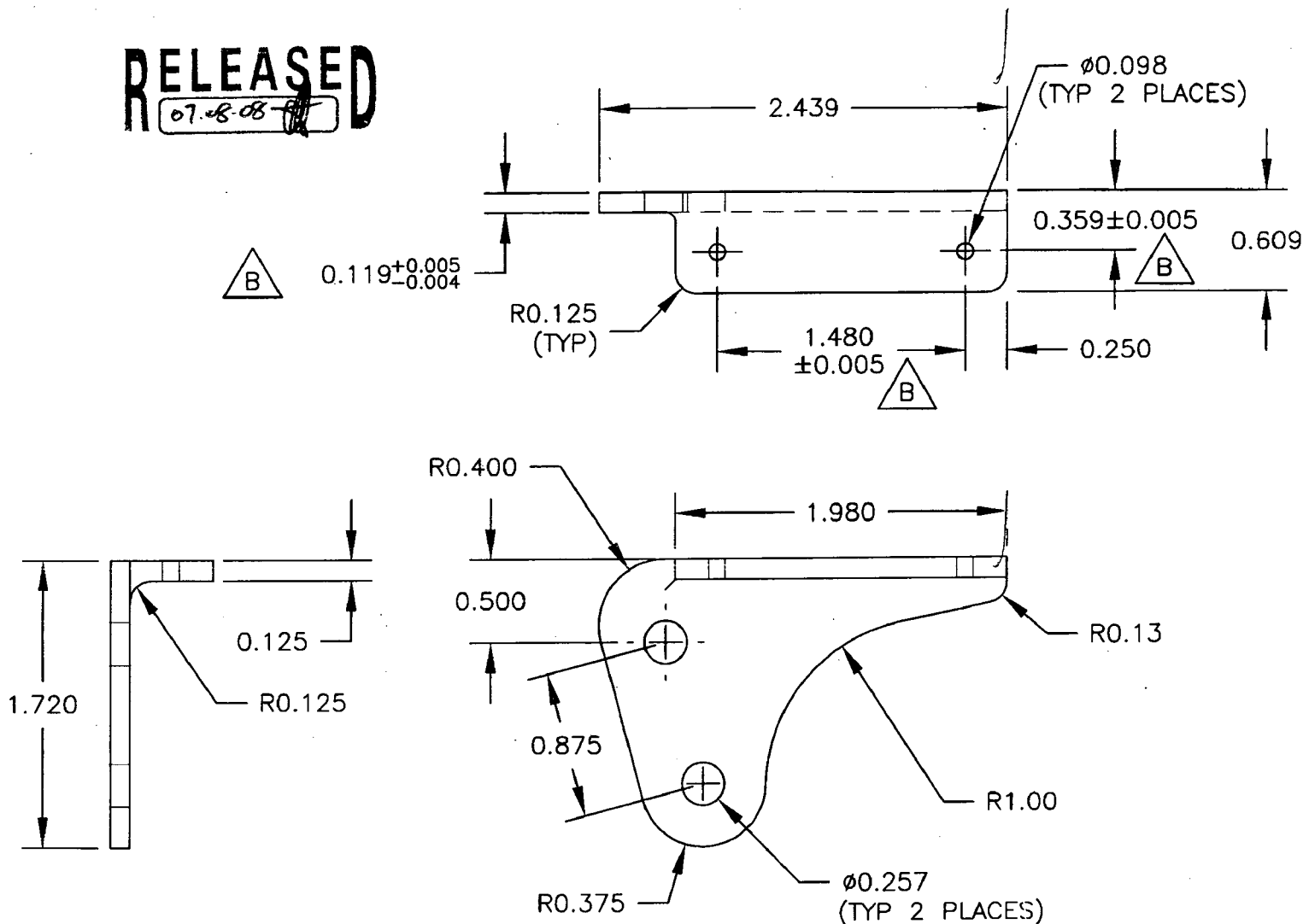
Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

**RELEASED**  
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

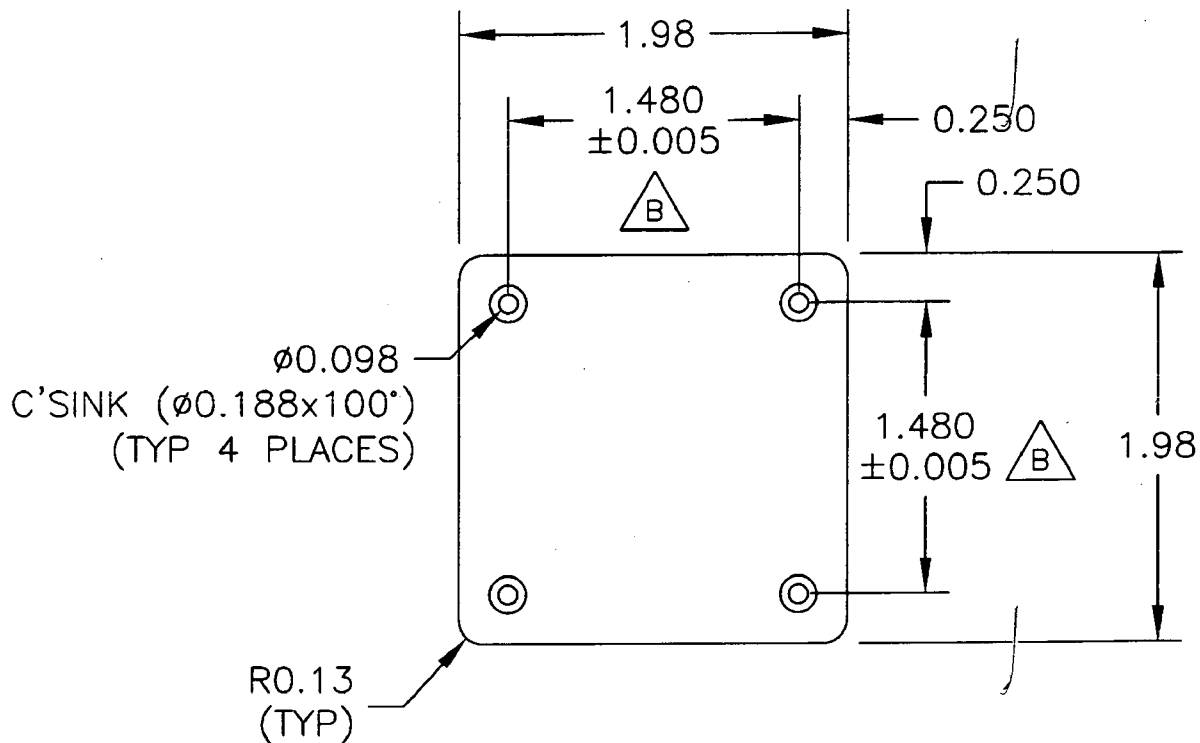
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CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED  
07.08.08



### D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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